

Work Order ID 65154

Thursday, January 06, 2011 3:32:11 PM



Page 1

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 1/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date: 1/1-01-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3209	Rev A

100



BAND SAW

Bandsaw

Memo

0.00

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

110



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine D3209-1 as per Folio FA345 and Dwg D3209-1 Identify as D3209-1

Deburr and Tumble

120



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

0.00

Quality Control

Work Order ID 65154

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

B.A 11/04/04

4

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

4 0 M 11/04/04

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

H B1-H-6

Powdercoat

Memo

0.00

Powder Coating

Note: Cover the hole for D3209-1 before powder coat. STARTTIME: 11:15 OVEN TEMPERATURE:300 FINISH TIME: 11:45

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Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

4 0 11/04/13 Log

QC

Memo

0.00

Quality Control

161



Small Fab

Memo

0.00

Small Fab

press fit bushing as per dwg

0.00

=7Mrk 11/04/13



170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

11 04 13 (4)

Work Order ID 65154

Page 4

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Accept



Setup

Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 1/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: SMALLFrob

0.00

1/4/15 f

Packaging

Memo

0.00

Packaging

190



QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

1/4/18 J
MF
11-04-15

Picklist Print

Thursday, January 06, 2011 3:32:16 PM

Page 1

Work Order ID: 65154



Parent Item: D3209-041



Parent Item Name: Bracket Assembly

Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A□04.06.09□New issue□KJ/RF□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3209-3		Manufactured	No			100	Each	43.0000	1	4			
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Bushing												m-f 11/04/13	
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Location Loc Qty Loc Code

ST045	43	
35633 ✓	2	QX
40930 ✓	41	QX

M6061T6B1.500X01.25		Purchased	No			170	f	20.0204	0.175	0.736842		
---------------------	--	-----------	----	--	--	-----	---	---------	-------	----------	--	--

0												21 11/03/22
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6061-T6 Bar 1.50 x 1.25												
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Location Loc Qty Loc Code

MAT10	20.02035	
107461	1.73315	
110936	18.2872	.34

DART AEROSPACE LTD	Work Order:	CS1541
Description: Bracket	Part Number:	D3209-1
Inspection Dwg: D3209	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>Amber</u>	Audited by:	<u>H.A.</u>	Prototype Approval:	N/A
Date:	11/03/31	Date:	11/04/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3209-041)	KJ/JLM	JLM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

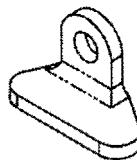
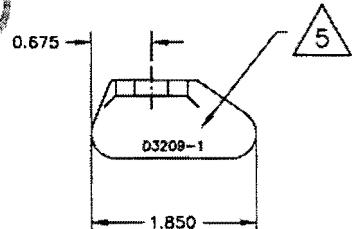
NOTE: Date & initial all entries



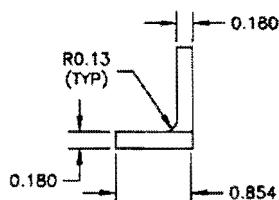
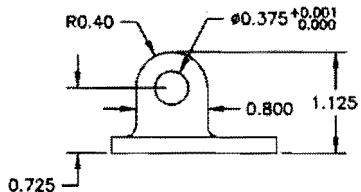
CCOPY
RELEASED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3209	SHEET 1 OF 1
DATE	04.01.27	TITLE	SCALE
		BRACKET	1:2
A	04.01.27	NEW ISSUE	

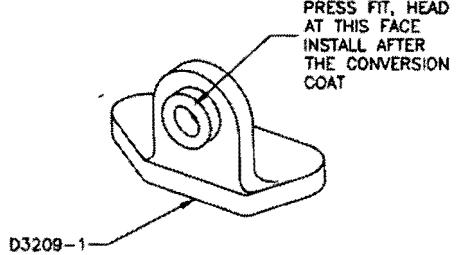
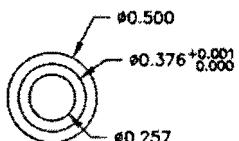
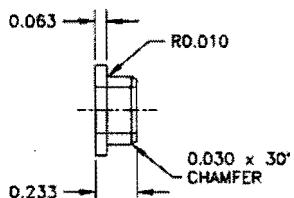
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04.04.05 AF



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65159
BL 11-01-1



2 D3209-1 BRACKET



3 D3209-3 BUSHING
SCALE 1:2

4 D3209-041 ASSEMBLY

D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries